

**D4106-1 SILL DOUBLER, LH**

**D4106-3 CREW DOOR DOUBLER, LH**

**D4106-5 SPACER, SILL DOUBLER**

**D4106-2 SILL DOUBLER, RH**

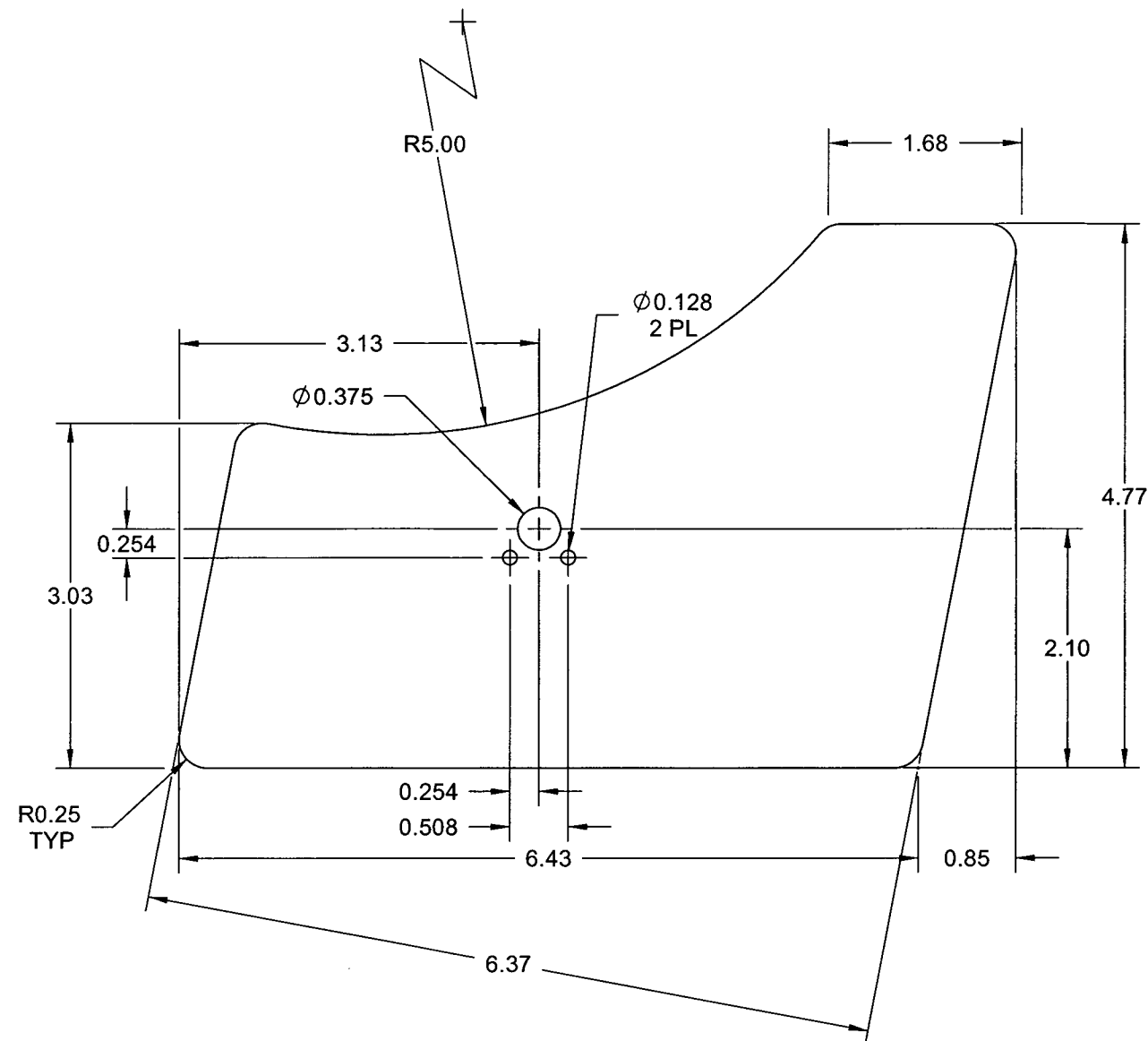
**D4106-4 CREW DOOR DOUBLER, RH**

**D4106-7 TEMPLATE**

**RELEASED**  
2010-09-23  
MM

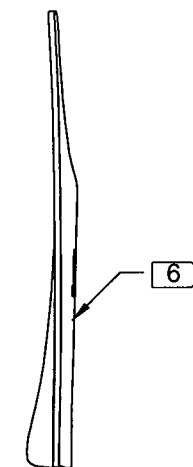
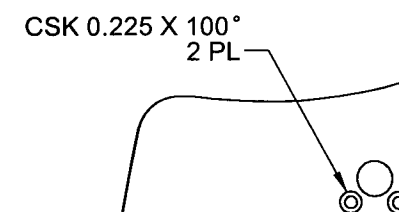
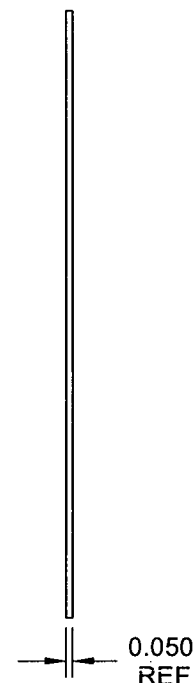
A	NEW ISSUE		JPH	10.07.15
REV.	DESCRIPTION		BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED		DRAWING NO. <b>D4106</b>		REV. A
MFG. APPR.				SHEET 1 OF 5
APPROVED		TITLE <b>DOUBLERS</b>		SCALE
DE APPR.				NTS
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D  
C  
B  
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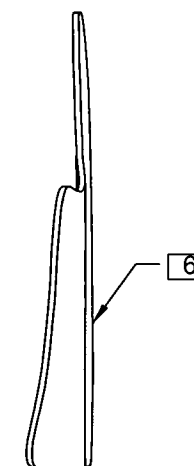
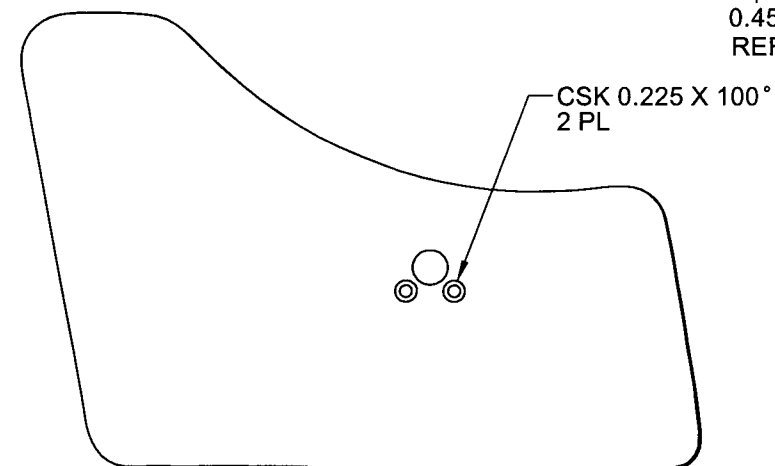
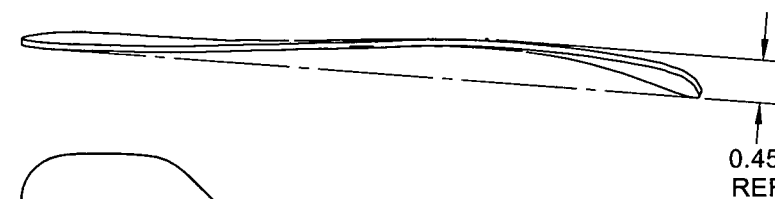


**D4106-1F FLAT PATTERN, SILL DOUBLER**

- NOTES:
- 1) MATERIAL -1F: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S18GA OR M303S18GA  
-1 & -2: MAKE FROM D4106-1F.
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION -1 & -2: IDENT P/N D4106-X AND B/N PER QSI 044 6.1
  - 7) WEIGHT -1 & -2: 0.34 lbs
  - 8) FORM & INSPECT PER TEMPLATE DT9646 FOR D4106-1  
DT9647 FOR D4106-2



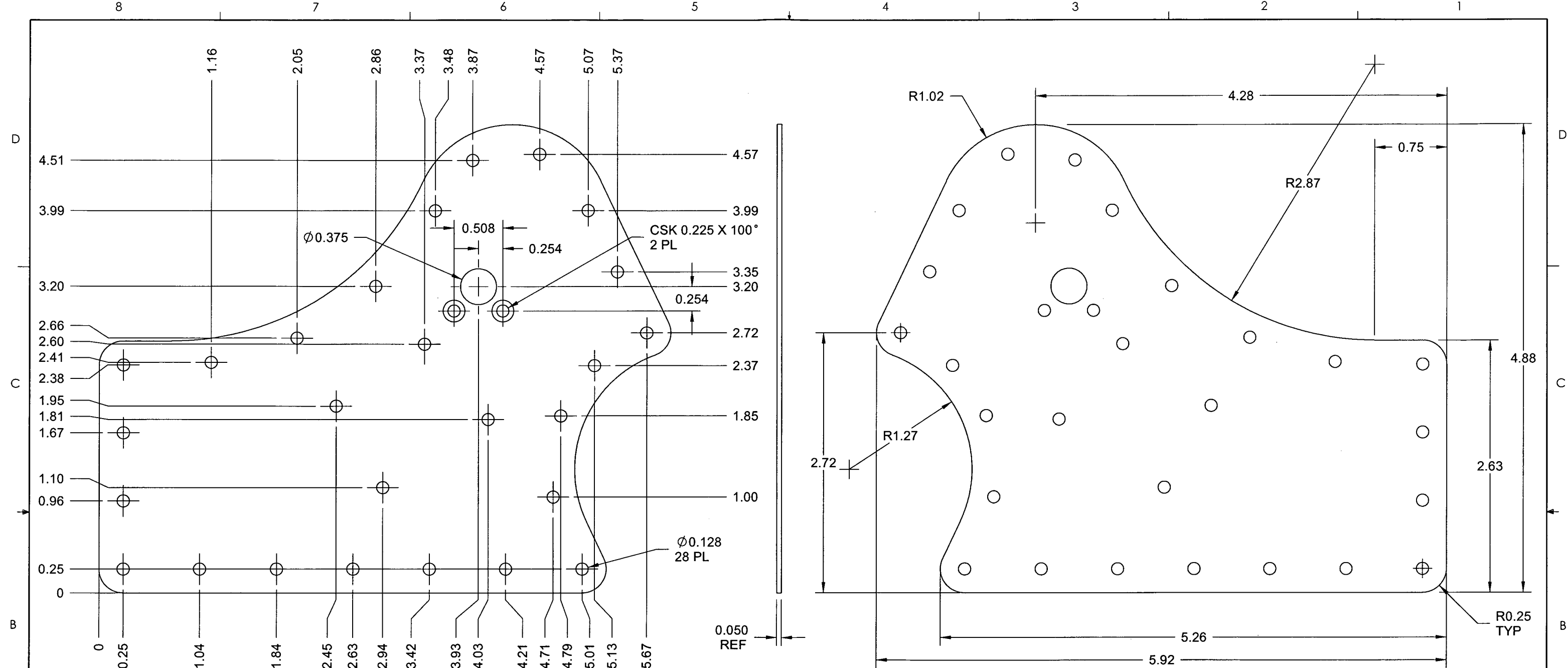
**D4106-1 SILL DOUBLER, LH 8**  
(MAKE FROM D4106-1F)



**D4106-2 SILL DOUBLER, RH 8**  
(MAKE FROM D4106-1F)

**RELEASE**  
2010-09-13

DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4106</b>	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>DOUBLERS</b>	NTS
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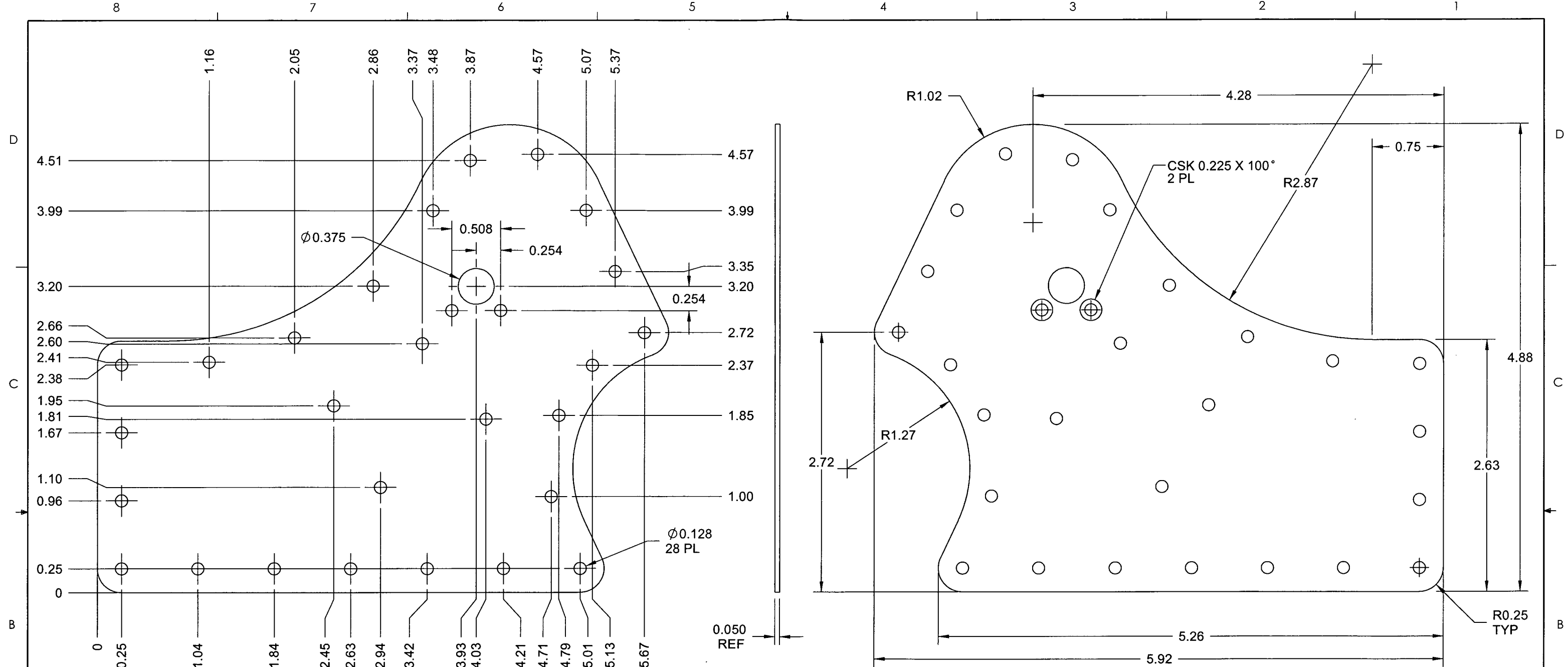


**D4106-3 CREW DOOR DOUBLER, LH**

**RELEASED**  
2010-09-23  
ND

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S18GA OR M303S18GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENT P/N D4106-3 AND B/N PER QSI 044 6.1
  - 7) WEIGHT: 0.27 lbs

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DRAWN	JPH		
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MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 5	
APPROVED	<i>[Signature]</i>	TITLE <b>DOUBLERS</b>	SCALE NTS
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DATE	<b>10.07.15</b>		

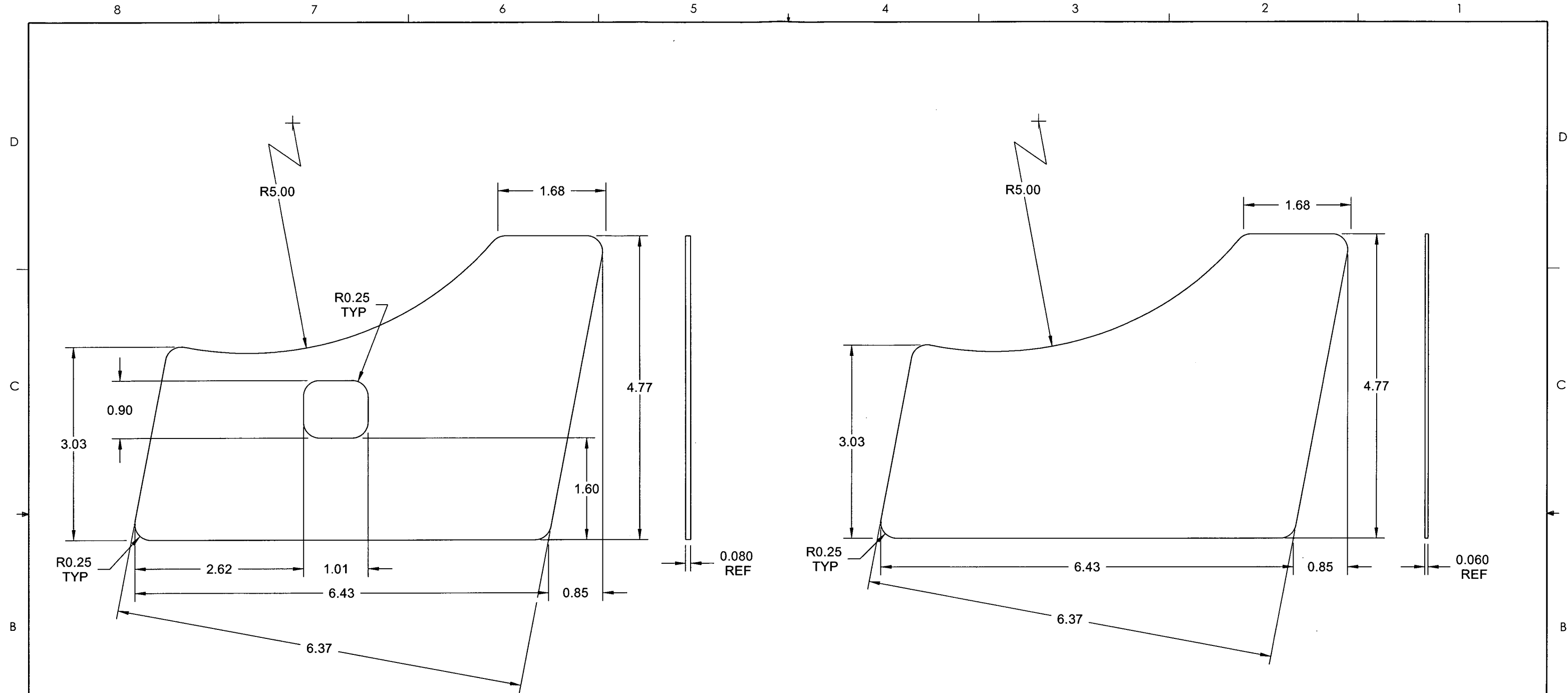


**D4106-4 CREW DOOR DOUBLER, RH**

**RELEASED**  
2010-09-23

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.050 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S18GA OR M303S18GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENT P/N D4106-4 AND B/N PER QSI 044 6.1
  - 7) WEIGHT: 0.27 lbs

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MFG. APPR.	<i>[Signature]</i>		SHEET 4 OF 5
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DATE	10.07.15		



**D4106-5 SPACER, SILL DOUBLER**

**D4106-7 TEMPLATE**

**NOTES:**

- 1) MATERIAL -5: KYDEX 6185 SHEET, 0.080 THK  
REF DART MKYD6185S.080-P3-52068 OR MKYD6185S.080-P3-62015
- 7: LEXAN 9034 SHEET, 0.060 THK  
REF DART MLEXS.060-9034-08  
OR POLYCAST II CLEAR ACRYLIC, .060 THICK.  
REF DART M-ACRYLIC-S.060
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4106-X PER QSI 044 6.1
- 7) WEIGHT -5: 0.08 lbs  
-7: N/A

**RELEASED**  
2010-09-23  
NW

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DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4106</b>	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		<b>DOUBLERS</b>	NTS
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